

Work Order ID 86765

86765

Page 1

July-06-12 2:20:00 PM

Item ID: D3016-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Seat Frame Assembly
 Start Date: 7/06/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/17/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 12-07-9 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3016	RevA / DEO A-1								
100	Weld per dwg A/R 4130 rod Batch: <u>M118875</u>	0.00							
100	Large Fab								<u>12-7-26</u>
Large Fab	Memo	0.00							
Large Fab	1-Cut all tubes as per Dwg D3016								
	2-Deburr								
	3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig DT8597								
	4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041								
	5- Assemble brackets and gusset per dwg and weld								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									<u>12/07/27</u>
QC	Memo	0.00							
Quality Control									

DAS
18
8-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
130 *130* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo Install paint screws on fitting ends START TIME: 11:15 OVEN TEMPERATURE: 320°F FINISH TIME: 11:45	0.00 0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

W121279

IX 0 M-L 12/37/31

1 x 0 M-L 12/37/31

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Item ID: D3016-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Seat Frame Assembly

Stop ***NS2***

Start Date: 7/06/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 8/17/12 Req'd Qty: 1.00 * 1 *

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

Insp.
Stamp

150

Identify as per dwg & Stock Location

GA

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/8/11 *JD*

MLJ 12/08/04

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Picklist Print

July-06-12 2:20:00 PM

Page 1

Work Order ID: 86765

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 7/06/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19New issueECIPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.049 4130 RD Tube .750 x.049W		Purchased	No			100	f	87.3900	4.3	4.5263158			
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				MAT033				87.39					
				120350				47.08					
				121025				40.31					
M4130NT0.500W.049 4130 RD Tube .500 x.049W		Purchased	No			100	f	38.9500	4.3	4.5263158			
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				MAT032				38.95					
				121025				38.95					
M4130NT1.000W.120 4130 RD Tube 1.00 x .120wall		Purchased	No			100	f	62.9500	1.5	1.5789474			
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				MAT033				62.95					
				117656				18.69					
				117973				44.26					
D3016-17 Gusset		Manufactured	No			100	Each	20.0000	2				
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				WA021				20					
				70872				12					
				70909				8					
D3016-13 Bracket		Manufactured	No			100	Each	4.0000	2				
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				WA021				4					
				76567				4					

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Picklist Print

July-06-12 2:20:00 PM

Page 2

Work Order ID: 86765

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 7/06/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

D3016-15
Gusset

Manufactured No

100 Each 6.0000

2

EL² 12-7-25

Location

Loc Qty

Loc Code

WA

6

77579

6

2

D3020-1

Fitting

Manufactured No

100 Each 16.0000

4

EL⁴ 12-7-25

Location

Loc Qty

Loc Code

WA

13

85978

13

4.

WA021

3

76579

3

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Shop Packet Print

Page 2

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *86765*

12079

DEO ATTACHED

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01.05.30

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

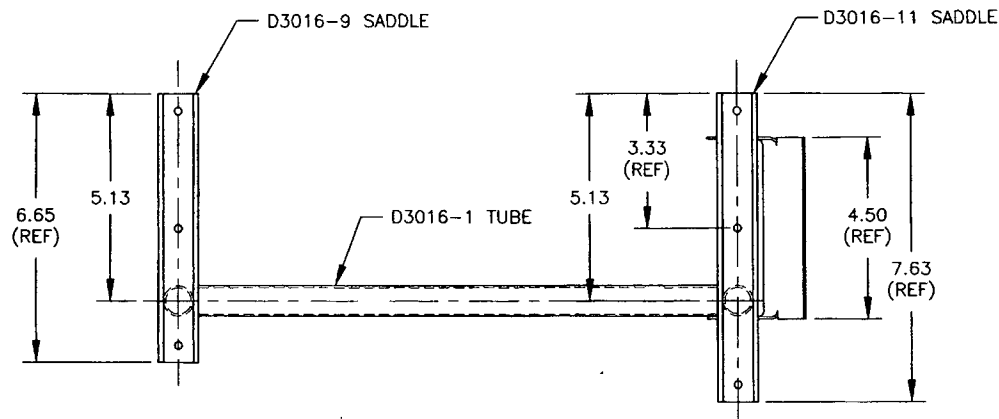
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

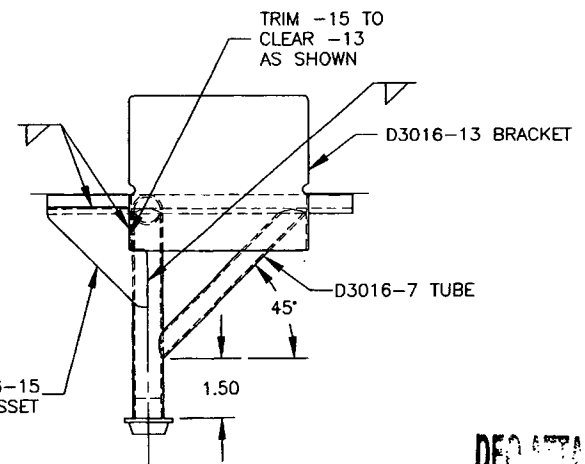
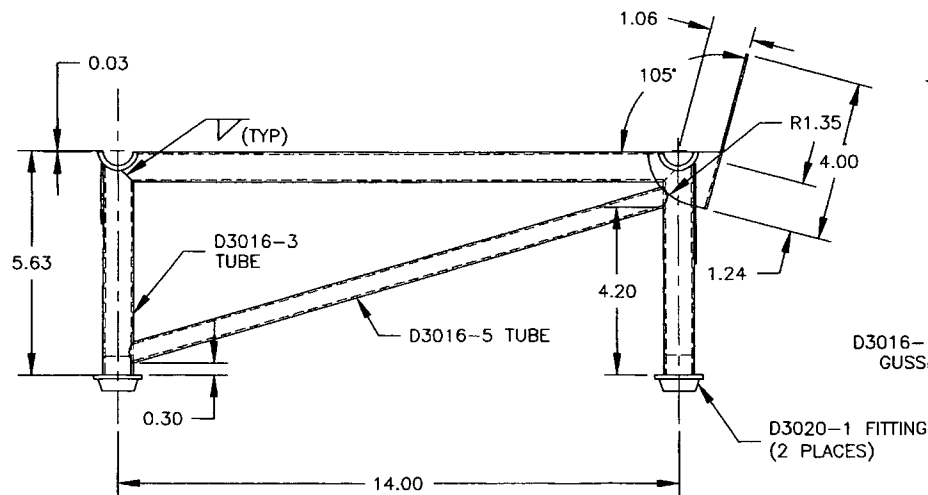
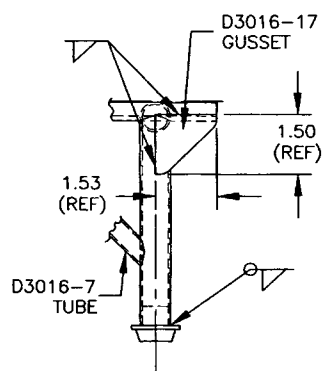
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D3016-041 SEAT FRAME ASSEMBLY



86765



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01.05.30

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	#	APPROVED	#				DRAWING NO.	D3016	SHEET 2 OF 3
		DATE		01.05.18		TITLE		SEAT FRAME ASSEMBLY	SCALE	1:3	

Dart Aerospace Ltd

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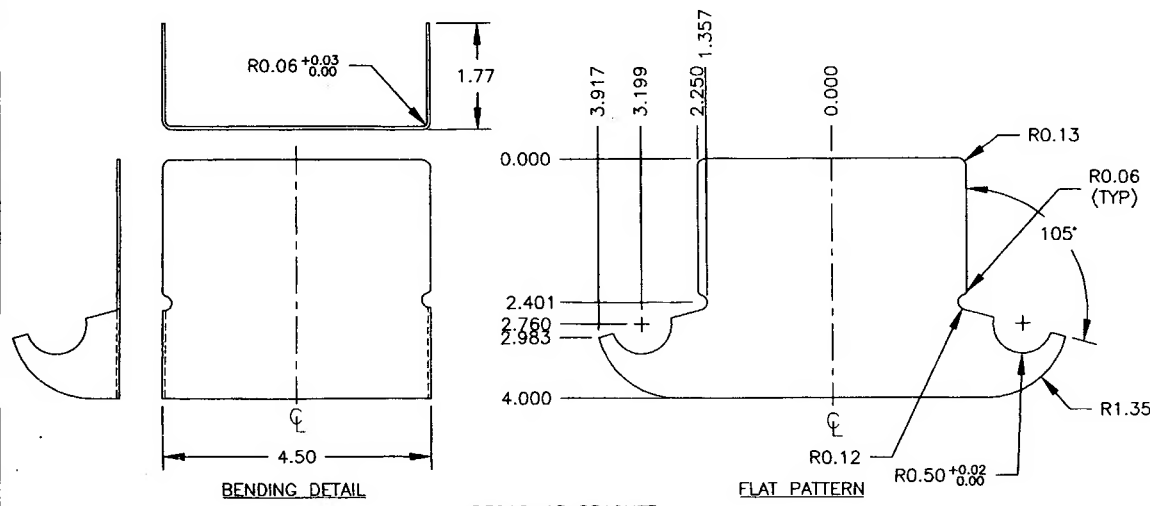
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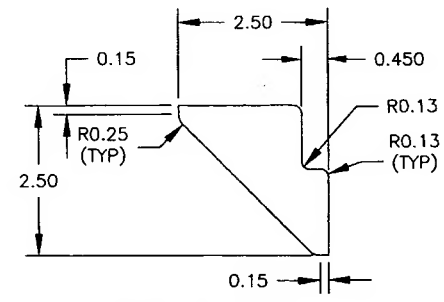
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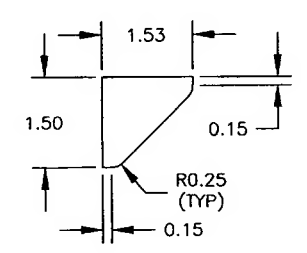
86-765



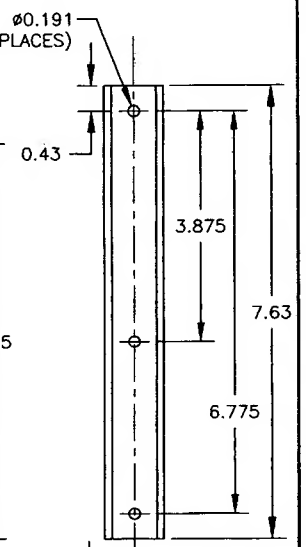
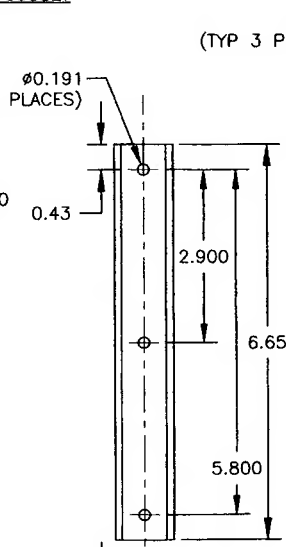
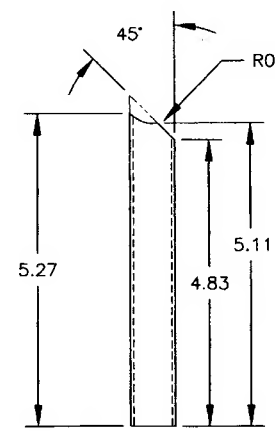
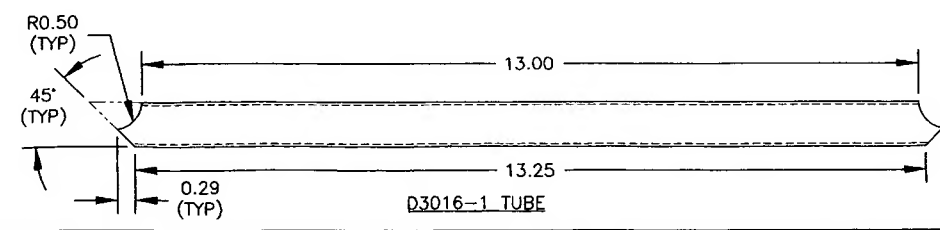
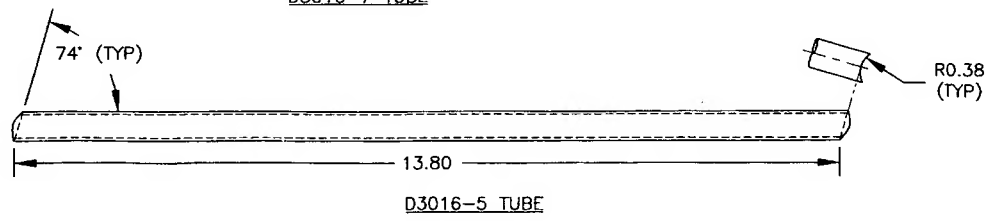
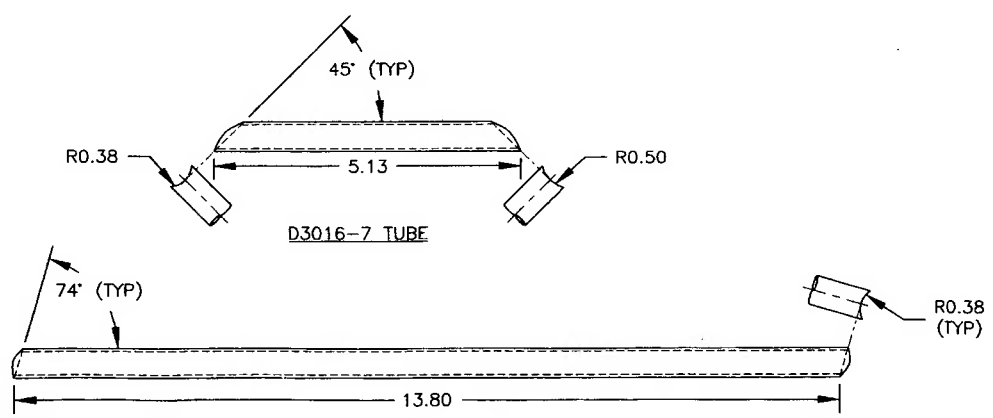
D3016-13 BRACKET



D3016-15 GUSSET



D3016-17 GUSSET



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		DATE		DRAWING NO.	REV. A
		01.05.18		D3016	SHEET 3 OF 3
				TITLE	SCALE
				SEAT FRAME ASSEMBLY	1:2

DEO ATTACHED
RELEASED
9.05.30

W/O:		WORK ORDER CHANGES					
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DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 1	CHECKED JP	MFG. APPR. RE	APPROVED WAP		DE APPR. -H		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29		DATE 10.01.29		

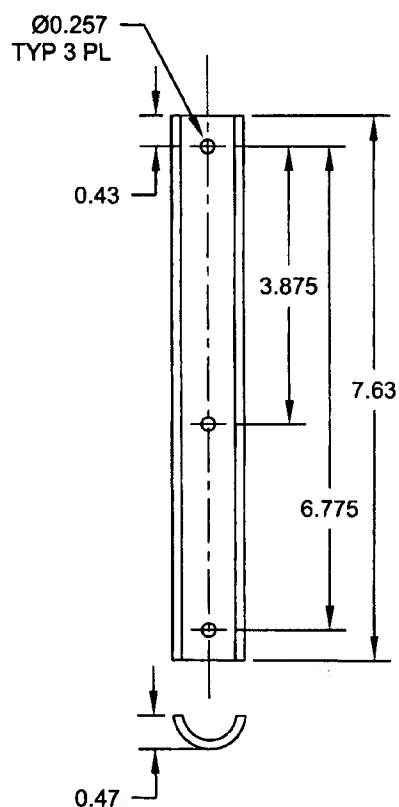
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

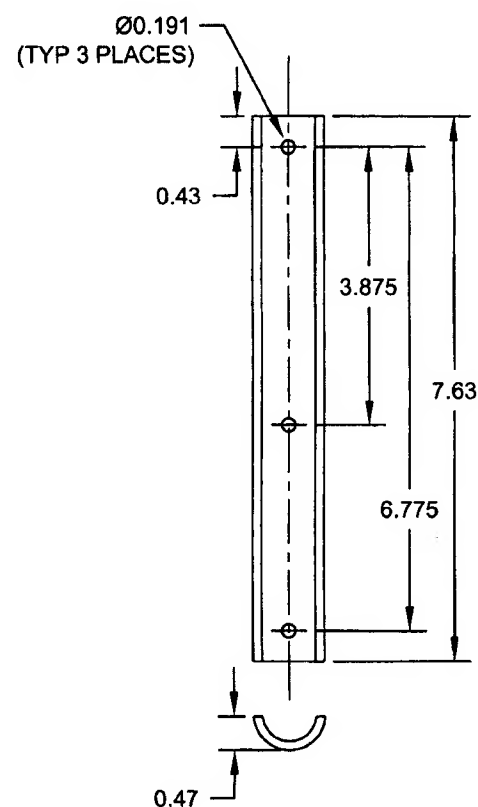
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE

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